



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D3560-3
Job Sheet 200654



DAS
21
9-89

Part No: D3560-3

Job Qty: 8 pcs

Part Name: Arm



Part Weight: 0 lbs

Job Created: 9/13/19

Due Date: 10/7/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description: SIOP

Note: DWG REV D IPP Rev:A New Issue 06-11-10 JLM use-043 IPP REV:B 13.06.03 PER DWG REV.F DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs	10/7/19	10/7/19	0.00	0.01	Bandsaw - 1		On 19-10-13 DJP 19-10-21
110	HAAS 4 Axis - B4B	8 pcs	10/7/19	10/7/19	0.49	5.97	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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Container No: S223363



Part: D3560-3

Job No: 200654

Serial No/Batch: S223363

Inspection:

Inspector:

Print Date:

Instructions: Various STC's

Date: 10/17/19

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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	DSP 19-10-20
					Conventional Mill - 1 - B4B	
124	Conventional Mill - 1 - B4B	8 pcs	10/7/19	0.00 0.70	Conventional Mill - 2 - B4B	19/11/11
126	QC 2	8 pcs	10/7/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	19/11/11
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	8 pcs	10/7/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	J.C. - 19-11-02
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 48	

				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
210 Packaging 3-1 - Stock - B4B 8 pcs	10/7/19	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	8 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Cut blanks 15.500" long Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Mill as per Folio FA695 Rev: <u>D</u> & Dwg D3560 Rev: <u>D</u> 120 - (QC2- Inspect parts off machine FAI/FAIB) 124 - (Manufacture as per dwg) 126 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 210 - (Identify as per dwg & Stock Location: _____), LOCATION: WA003 220 - (QC21- Final Inspection - Work Order Release), 2-Deburr per dwg D3560					

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NOV 2 1 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	11.1200 ft (1.39 ea)	100-Bandsaw - 1	S 200 445

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.500X05.000	11	53	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	0.507Inches + 0.000 - 0.001	0.507 0.506	Diameter	0.5065
2	Arm	0.196Inches + 0.005 - 0.001	0.201 0.195	Diameter	0.196
3	Arm	1.000Inches + 0.010 - 0.001	1.010 0.999	Diameter	1.005
4	Arm	0.900Inches + 0.010 - 0.001	0.910 0.899	Diameter	0.903
5	Arm	0.500Inches ± 0.010	0.510 0.490		0.499
6	Arm	0.250Inches ± 0.010	0.260 0.240		0.250
7	Arm	0.275Inches ± 0.010	0.285 0.265		0.275
8	Arm	0.188Inches ± 0.010	0.198 0.178		0.188
9	Arm	1.750Inches ± 0.010	1.760 1.740		1.750
10	Arm	1.702Inches ± 0.010	1.712 1.692		1.707
11	Arm	0.385Inches ± 0.010	0.395 0.375	Diameter	0.385
12	Arm	100.000Degrees ± 0.500	100.500 99.500	Angle	100°
13	Arm	0.250Inches ± 0.010	0.260 0.240	Depth	0.245

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19-10-20

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	DEPARTMENT/PROCESS		MRB (QS1042)				
Date : _____		Sequence #: _____		QTY Affected : _____				
Description Work Order Deviation			Disposition					
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____			FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
						Completed By		
						Lead hand / Supervisor		
						QC / QA Coordinator		